

Date: Friday, 24/10/2008 3:32:16 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : TUBE
Job Number : 42963	
Estimate Number : 13491	
P.O. Number :	Part Number : D37703
This Issue : 24/10/2008 S.O. No. :	Drawing Number : D3770 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL / MED FAB	Drawing Revision : B
Previous Run : 40979	Material :
Written By :	Due Date : 03/11/2008 Qty: 28 Um: Each
Checked & Approved By : <u>JUD 08.10.24</u>	
Comment : Est Rev:A 08-07-21 revB as per dwg DD verified by:EC Est Rev:B Added Drilling Tooling 08-08-27 JLM Verified By:EC	

Additional Product

Job Number:



Seq. #: Machine Or Operation:

Description :

1.0 M6061T6T1000W065 6061T6 RD TUBE 1.00 x .065w



Comment: Qty.: 1.9031 f(s)/Unit Total: 53.2875 f(s)

6061T6 TUBE (1.00" x 0.65" wall)

batch: M109116m-h 09/01/27

(28x)

2.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-cut tube to length as per dwg D3770

2-drill holes thru to finish size as per dwg D3770 Using DT9412

3- deburr

FF 09/01/28
m-h 09/01/27 (28x)
m-h 01/01/28 (28x)

(28x)

3.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

509/01/28 (28x)
counter

4.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MS 09-01-28

(28x)

5.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FF 09/01/28

(28x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: TUBE

Job Number: 42963

Part Number: D37703

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



28

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 251

9/1/08

SP

7.0

QC21

FINAL INSPECTION/W/O RELEASE



09/02/02

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



JUD 09.01.29 (8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

7

6

5

4

3

2

1

D

D

C

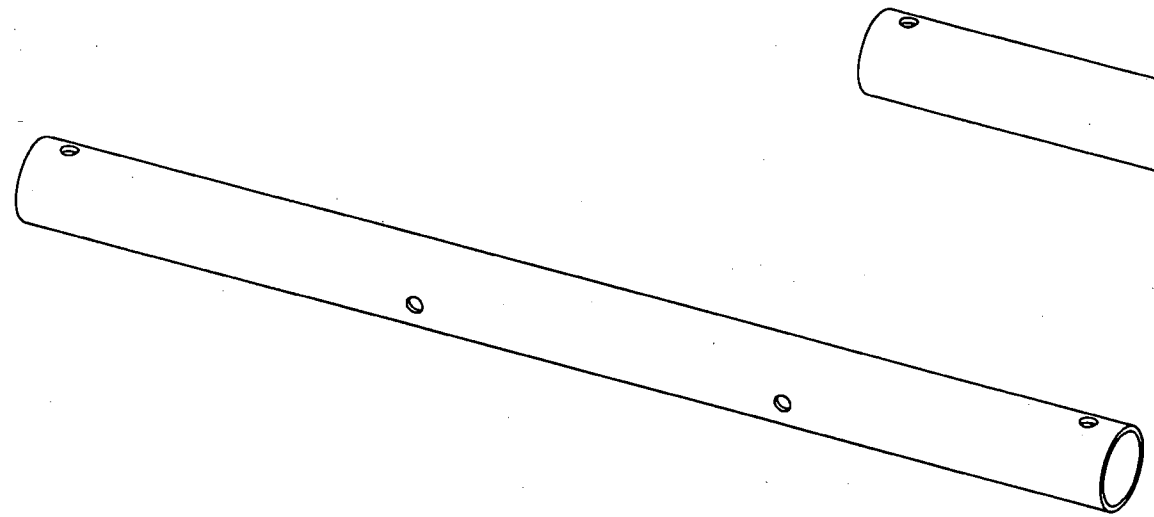
C

B

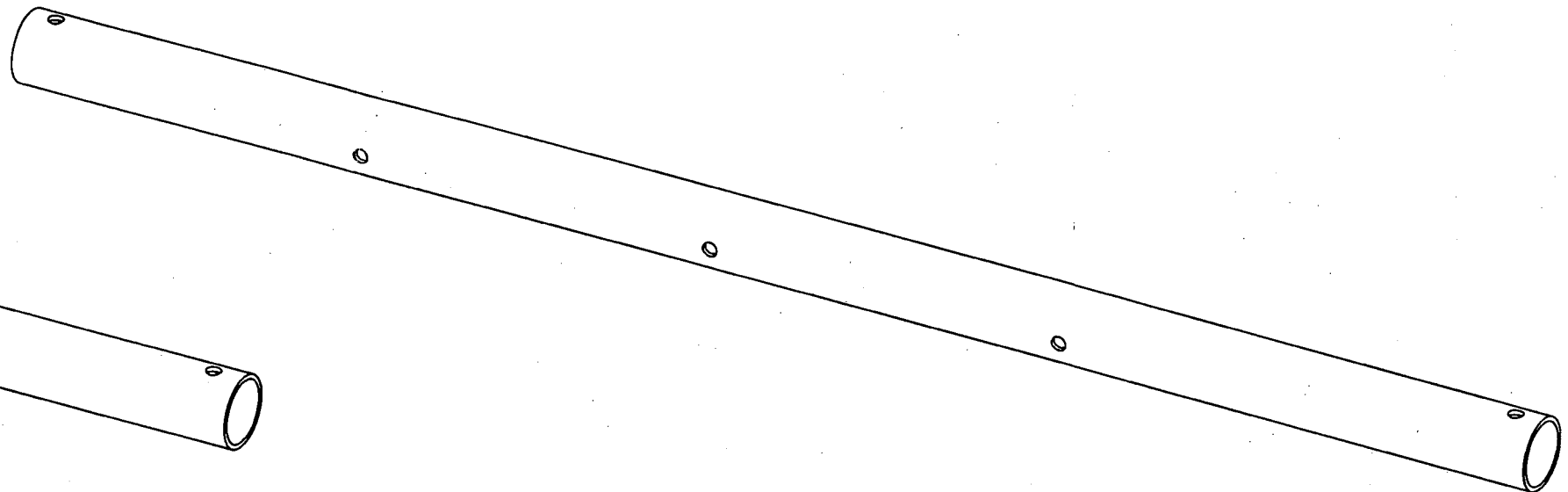
B

A

A



D3770-1 TUBE



D3770-3 TUBE

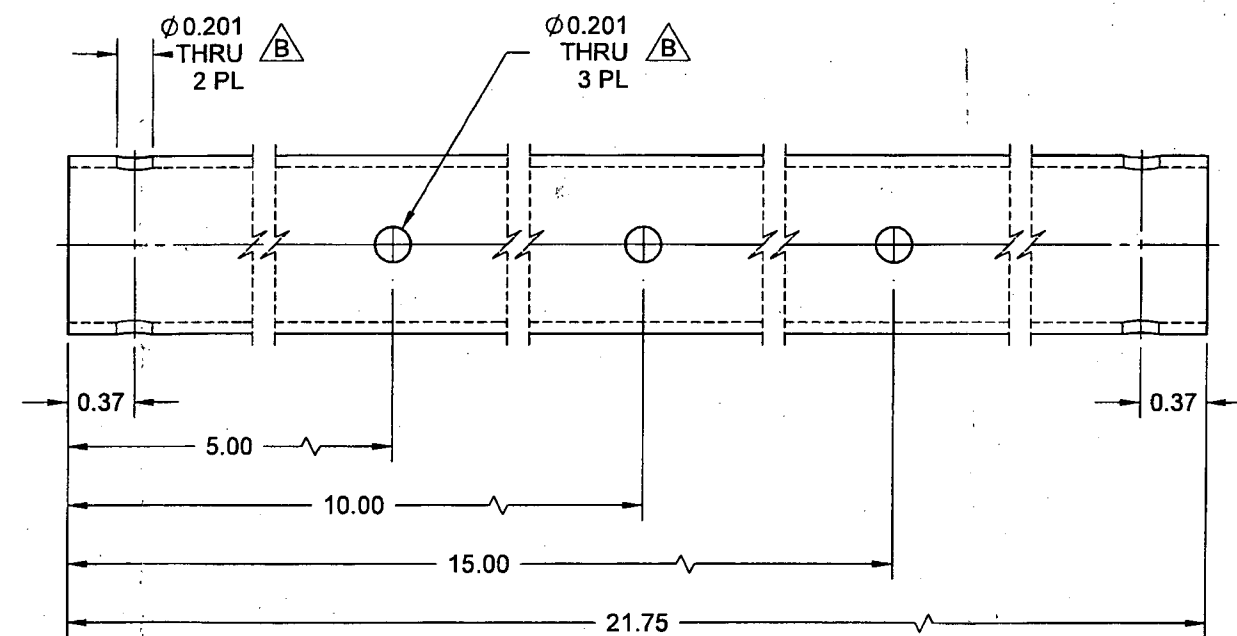
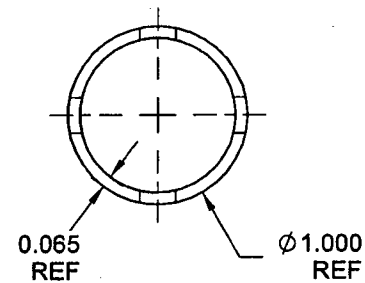
NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING (1.00" X 0.065" WALL) PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 (REF. DART SPEC. M6061T6T1.000W.065)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3770-1, 0.25 lbs
D3770-3, 0.40 lbs

RELEASED
08-07-10

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B	CHANGE HOLES SIZE TO 0.201	HS	08.06.23
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	Per [Signature]	DRAWING NO.	REV. B
MFG. APPR.	[Signature]	D3770	SHEET 1 OF 3
APPROVED	[Signature]	TITLE	SCALE
DE APPR.	[Signature]	TUBE	NTS
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D3770-3 TUBE

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CHECKED	PA	DRAWING NO.	REV. B
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APPROVED	MA	TITLE	SCALE
DE APPR.	MA	TUBE	NTS
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